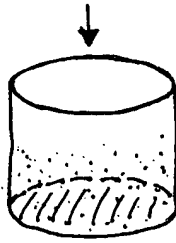
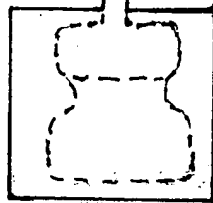


FIG. 1

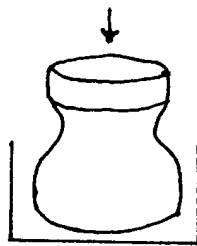
Binder + Water + Optional Additives



BLEND



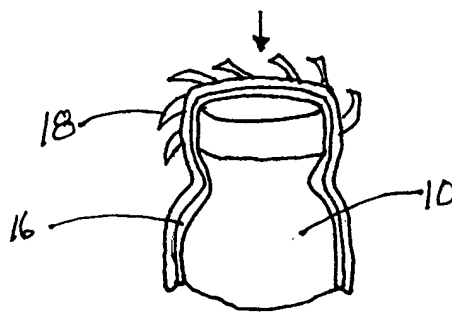
MOLD



DRY



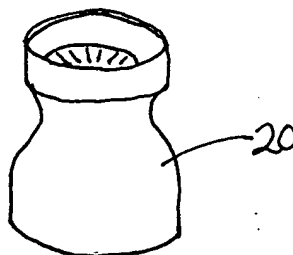
FINISH



FABRICATE

SOLVENT

WASH/FLUSH



COMPOSITE PART
WITH CORE REMOVED

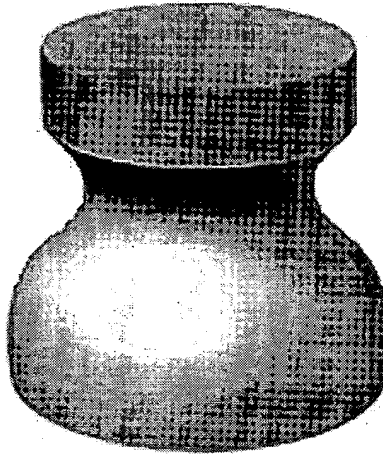


FIG. 2